

Date: Tuesday, 06/01/2009 10:04:20 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BK117 SKIDTUBE ASSEMBLY
 Job Number : 44390A
 Estimate Number : 12898
 P.O. Number :
 This Issue : 06/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D117762041
 First Issue : // Type : SKIDTUBES Drawing Number : D3582 REVA
 Previous Run : 44389A Project Number : N/A
 Material :
 Due Date : 31/01/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JD 09-01-06
 Comment : Est Rev:A 07.06.11 New Issue EC
 Est Rev:B 08-02-22 change to revA as per dwg DD verified
 by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D117-762-041 CHG001 N/A *AG*

2.0 D2962150 3.540 Outer Tube, Extrut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion *15-28672*

*MB**09-01-06*

3.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

*MB**09-01-06*

4.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

09-01-06

Bend tube as per program on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A".

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

2-Cut Aft end at VC using DT8185

3-Deburr ends

4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

5-Locate DT 8973 & Drill Ground wire hole on top of Tube.

6-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

7-Drill pilot holes for wearplates using DT8974

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

9- open ground wear holes to 0.391" as per section B-B

10-Open Aft Cap holes using .209" drill.

11-Deburr holes.

MS 09-01-06

fm
09-01-07

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B 14101 BE 09/01/07

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch:

m109560/m109213

BE 09/01/07

2-Grind flush

fm 09-01-08

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8.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/01/08 *(H)*

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/01/08 *(H)*

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

pm 09-01-08

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(H)

9-1-8

12.0	D2971	Cross Bolt Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cross Bolt Spacer

batch

B 39001

BE 9-01-12

13.0	D2973	Cross Bolt Spacer
------	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cross Bolt Spacer

Batch:

B 14636

BE 9-01-12

14.0	D36621	Crossbolt Spacer
------	--------	------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

SPACER

batch

B 39585

BE 9-01-12

15.0	D36623	Crossbolt Spacer
------	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACER

batch

B 37190

BE 9-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D35841

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEB

D 44422 Pmc 09-01-08

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .750"(4Places) as per Dwg D3582, section B-B

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M109983

Exp Date: 09-07-11

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: M109560

6-Grind welds flush

Pmc 09-01-12

Pmc 09-01-08

OR 09/01/12

Tools: E

18.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/01/13 (X)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/13 (X)

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109996

START TIME:

15:45

OVEN TEMPERATURE:

320°

FINISH TIME:

16:15

BR

09-02-09 (X)

FR 09/02/09 (X)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/02/10 (29)

22.0

ALS41032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total: 36.0000 Each(s)

Insert

Batch: m108606

FL

23.0

ALS4428165

Inserts



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Inserts

batch m6989

***same as ALS7-428-165 QSI 0017 ***

FL

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3582.

FL 09/02/10 (1)

25.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B45616

FL

26.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPLATE

Batch: B42250

FL

27.0

D35089

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPLATE

Batch: B40359

FL 09/02/11 (1)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44390A

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	D350811	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Batch: B40398

WEARPLATE

FL

29.0	D350813	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPLATE

Batch: B38528

FL

30.0	D35583	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B42253

FL

31.0	D35589	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B40361

FL

32.0	D355811	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B40399

FL

33.0	D355813	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B42255

FL

34.0	AN3C4A	BOLT
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Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

BOLT

Batch: m110468

FL 09/02/11 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44390A

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	AN3C5A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m110468

FL

36.0	AN44A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch m108138

FL

37.0	AN960C10L	washer
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Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

washer

Batch: m110023

FL

38.0	AN960JD10L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch m109632

FL

39.0	AN960JD416L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch m108583

FL

40.0	NAS1611012	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~6~~.0000 Each(s)

O-RING

batch: m108673

FL

41.0	NAS1611015	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~2~~.0000 Each(s)

O-RING

batch: m107178

FL

09/02/11

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 44390A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

NAS1611016

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

O-RING

batch: m107178

FL

43.0

D3492049

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PLUG ASSEMBLY

batch: 040356

FL

44.0

D3492051

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PLUG ASSEMBLY

batch: 034723

FL

45.0

D3492053

Plug Assembly



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

PLUG ASSEMBLY

batch: 0344063

FL

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: m109883

Exp Date: 09/11

3-Install Wearplates as per Dwg D3582,

Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: m109883

Exp Date: 09/11

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: m101223

FL (1)
09/02/11

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

5- Wing Walk as per Dwg D3043 and QSI 005 4.4

M110454

09-02-11

12

47.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/02/11

48.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762-041

Location:

PPP Rev:

PPP 44390

09/2/17

49.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



MF 09-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	App. QC Inspect

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

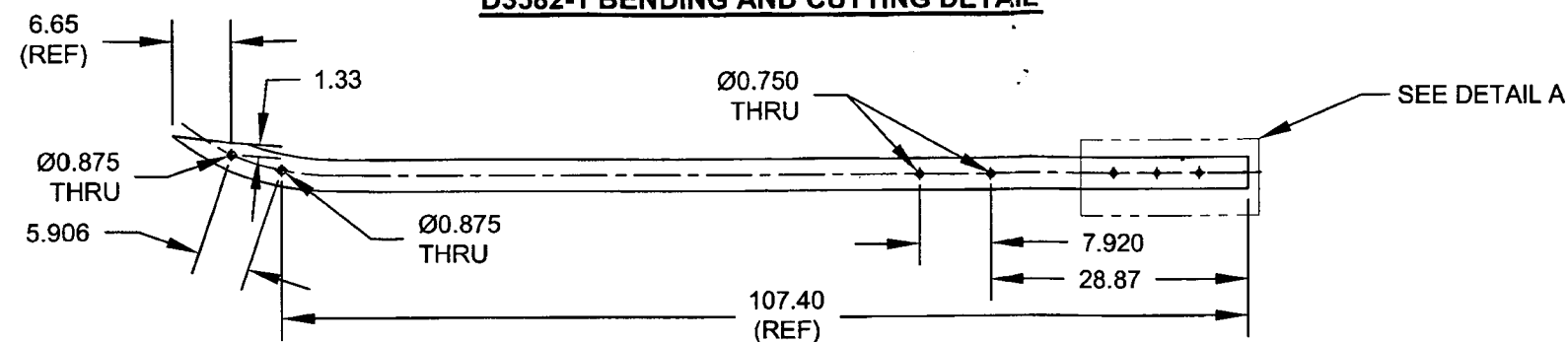
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

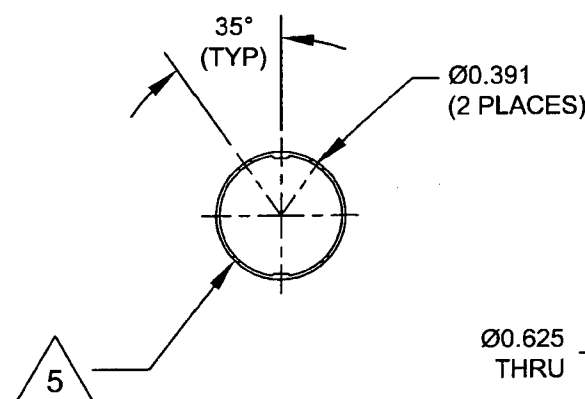
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



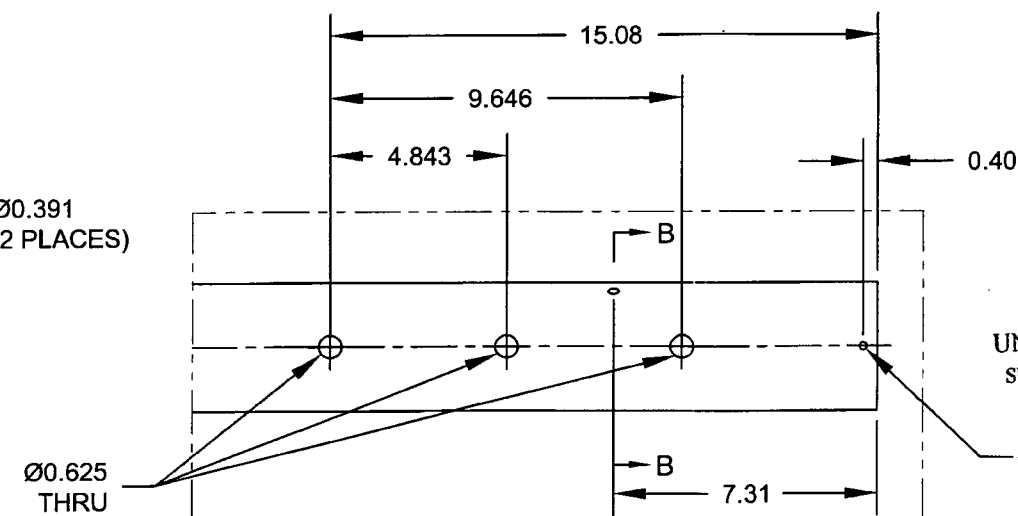
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

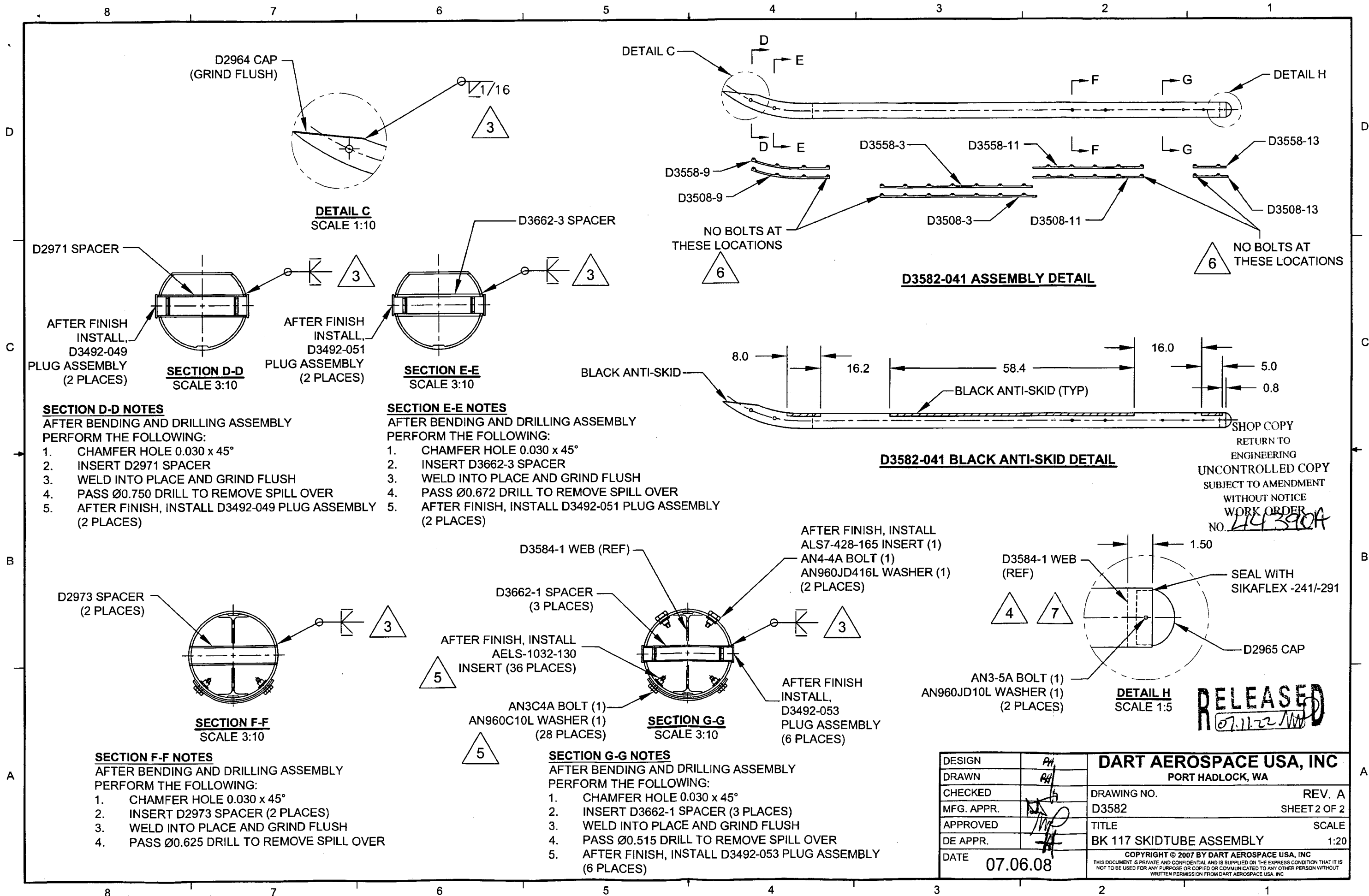


DETAIL A
SCALE 1:5

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
443904

RELEASED
07.11.22

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	SA	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	3	DRAWING NO.	REV. A
MFG. APPR.	NO	D3582	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY	1:2
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



NO. 169

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 40355A
Part number: D117 762 OVI
Description: Bk 117 skid
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sgt. D. D. D. Date of Test Coupon 08-08-21
Welder Barclay Elliot Date of Test Coupon 08-08-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld